

Date: Friday, 27/02/2009 10:36:05 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MOUNTING PLATE ASSY
<b>Job Number</b> : 46108	
<b>Estimate Number</b> : 13715	
<b>P.O. Number</b> :	<b>Part Number</b> : D36941
<b>This Issue</b> : 27/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3694 REV.C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 44721	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 13/03/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.27</u>	
<b>Comment</b> : Est Rev:A New Issue 09-01-13 JLM Verified By:DD Est Rev:B 09-02-20 rev.c asper dwg DD verified by:EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B1000X06000

6061T6 Bar1.00"x6.00"



Comment: Qty.: 0.6300 f(s)/Unit Total : 2.5200 f(s)

6061T6 Bar1.00"x6.00"

BATCH: 0110550

JL 09/03/08

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank 7.150" long

JL 09/03/08

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA731Rev: C & Dwg D3694 Rev: C

2-Tap 10-32 heli-coil holes Manually

2-Deburr per dwg D3694

JL 09/03/08

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3694-1 PAR #: N/A Fault Category: Prod / Machine Parts NCR: Yes No DQA: P Date: 09/04/03  
D3694-041 / D412-766 045  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: P Date: 09/04/06

NCR: <u>46108</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/03/08</u>	<u>3</u>	<u>- 1 part has flange dimension</u> <u>.125 +.030 - 0 &amp; .112</u> <u>* part lifted while machining</u> <u>R.C.B process.</u>	<u>[Signature]</u> <u>10/5/02</u>	<u>- All other parts are good.</u> <u>- scrap &amp; replace Qty 1</u> <u>B 110550</u>	<u>JL</u> <u>09/03/08</u>	<u>SS</u> <u>09/03/09</u>	<u>[Signature]</u> <u>10/5/02</u>	<u>[Signature]</u> <u>09/03/09</u>

NOTE: Date &amp; initial all entries

Date: Friday, 27/02/2009 10:36:06 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE ASSY

Job Number: 46108

Part Number: D36941

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09/03/09

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP/BR

09/03/10

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m109648

\*\*\*\*\*Mask all in surface as per Dwg D3694\*\*\*\*\*

START TIME:

13:55

OVEN TEMPERATURE:

300°

FINISH TIME:

14:25

UMP/FL

09/03/17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

555

9/3/18

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/19

Job Completion



mf

09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46108
<b>Description:</b> mounting plate		<b>Part Number:</b> D3694-1
<b>Inspection Dwg:</b> D3694	<b>Rev:</b> C	<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

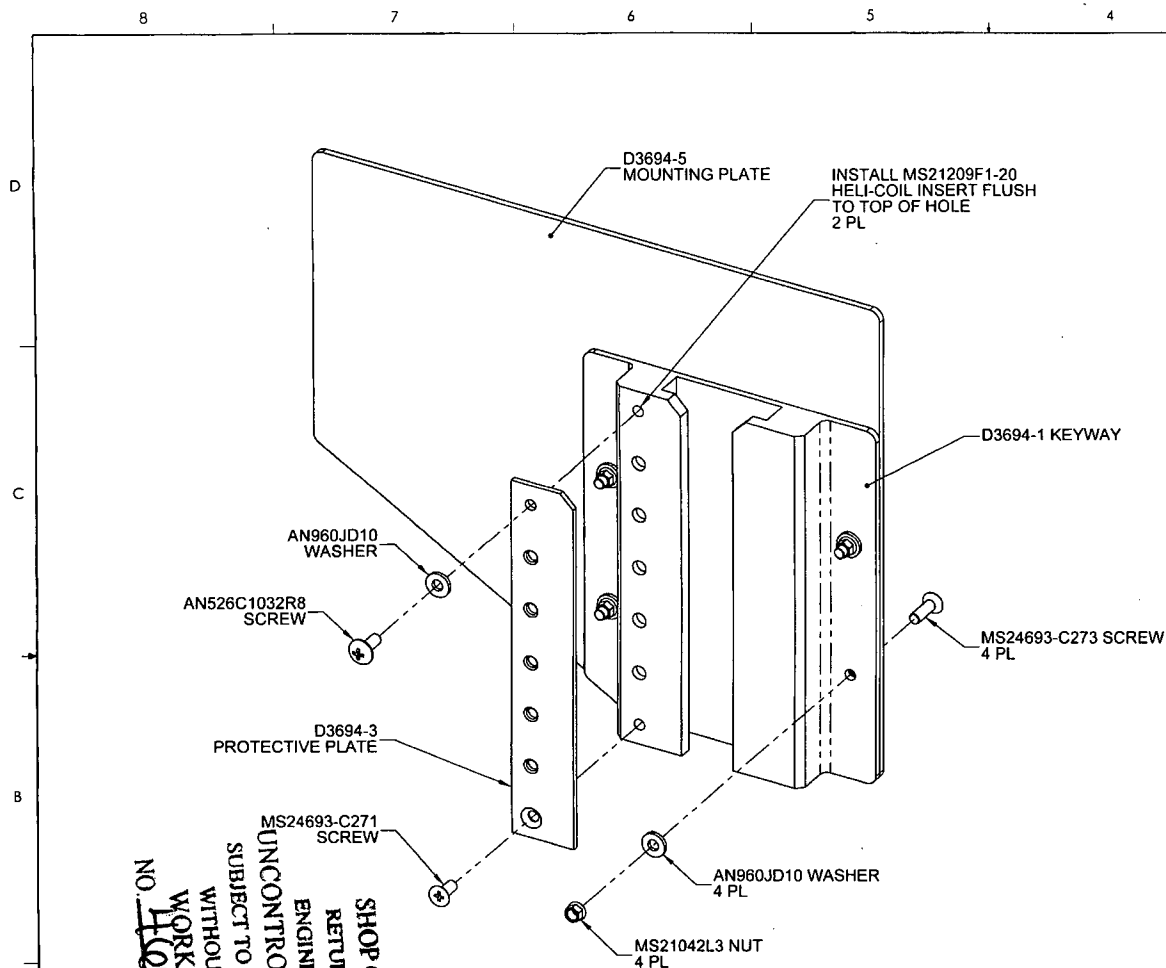
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.201	+ .005 - .001	.204	✓			
.673 deep	+ .010	.663	✓			
Ø.257	+ .005 - .001	.259	✓			
.200 deep	+ .010	.192	✓			
6.75	+ .030	6.750	✓			
6.000	+ .010	6.000	✓			
4.000	+ .010	4.000	✓			
1.000 pitch	+ .010	1.000	✓			
.375	+ .010	.375	✓			
4.114	+ .010	4.115	✓			
1.375	+ .010	1.375	✓			
2.000	+ .010	1.998	✓			
2.500	+ .010	2.500	✓			
Ø.204	+ .005 - .001	.206	✓			
.500	+ .010	.498	✓			
4.602	+ .010	4.602	✓			
<del>Ø.204</del>	<del>+ .005 - .001</del>					
1.000	+ .010 - 0	1.004	✓			
.130 x 45°	+ .030 + .5°	.105 x 45°	✓			
5.125	+ .030	5.125	✓			
.88	+ .030	.875	✓			
.125	+ .030 - 0	.138	✓			
5.60	+ .030	5.600	✓			

<b>Measured by:</b> JL	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/03/08	<b>Date:</b> 09/03/09	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





**D3694-041 MOUNTING PLATE ASSY**

**D3694-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

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 WORK ORDER  
 NO. 14008

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

RELEASED  
 09/05/10

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D8-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1). REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY: 1 MS24693-C271 SCREW WAS QTY: 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.05.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C  
 SHEET 1 OF 4  
 TITLE **MOUNTING PLATE ASSY** SCALE NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

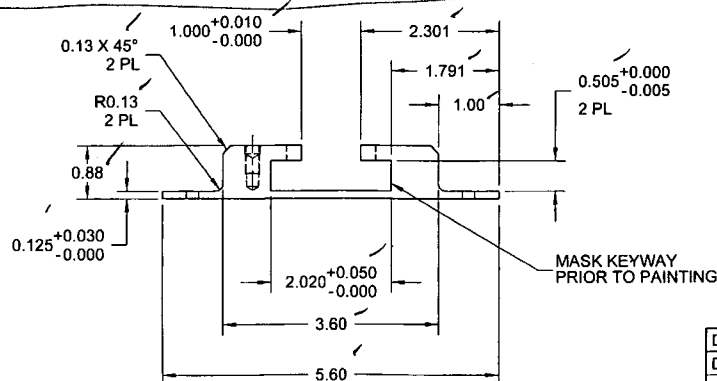
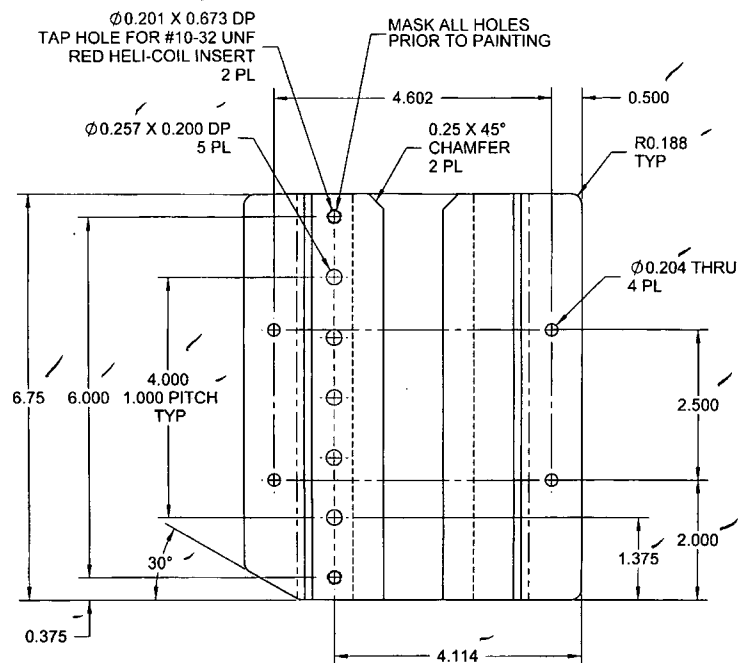
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3694-1 KEYWAY**

**D3694-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART  
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

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NO. 410108

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*9/10/05*

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MFG. APPR.		<b>D3694</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING PLATE ASSY</b>	NTS
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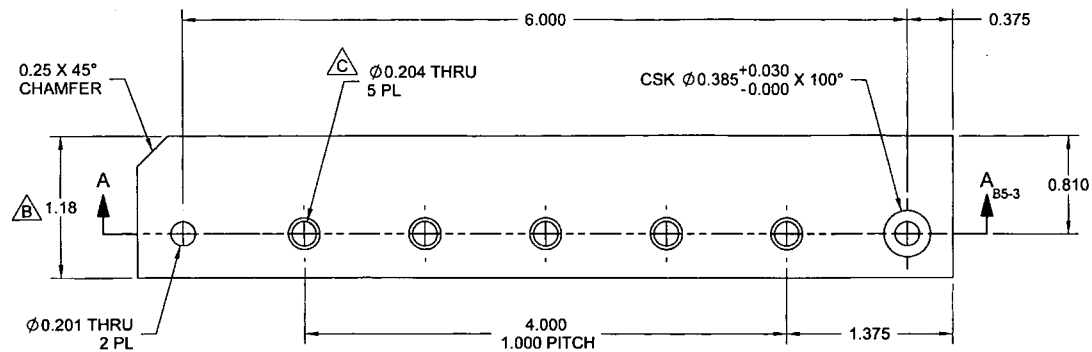
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

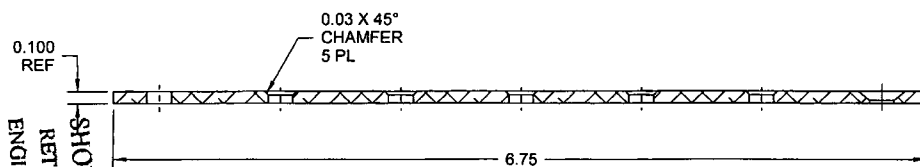
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3694-3 PROTECTIVE PLATE**



**SECTION A-A C3-3**

NO. 42108  
WORK ORDER  
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**D3694-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),  
PER PER AMS 5513 OR AMS 5524  
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

**RELEASED**  
07/02/05

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D3694	SHEET 3 OF 4
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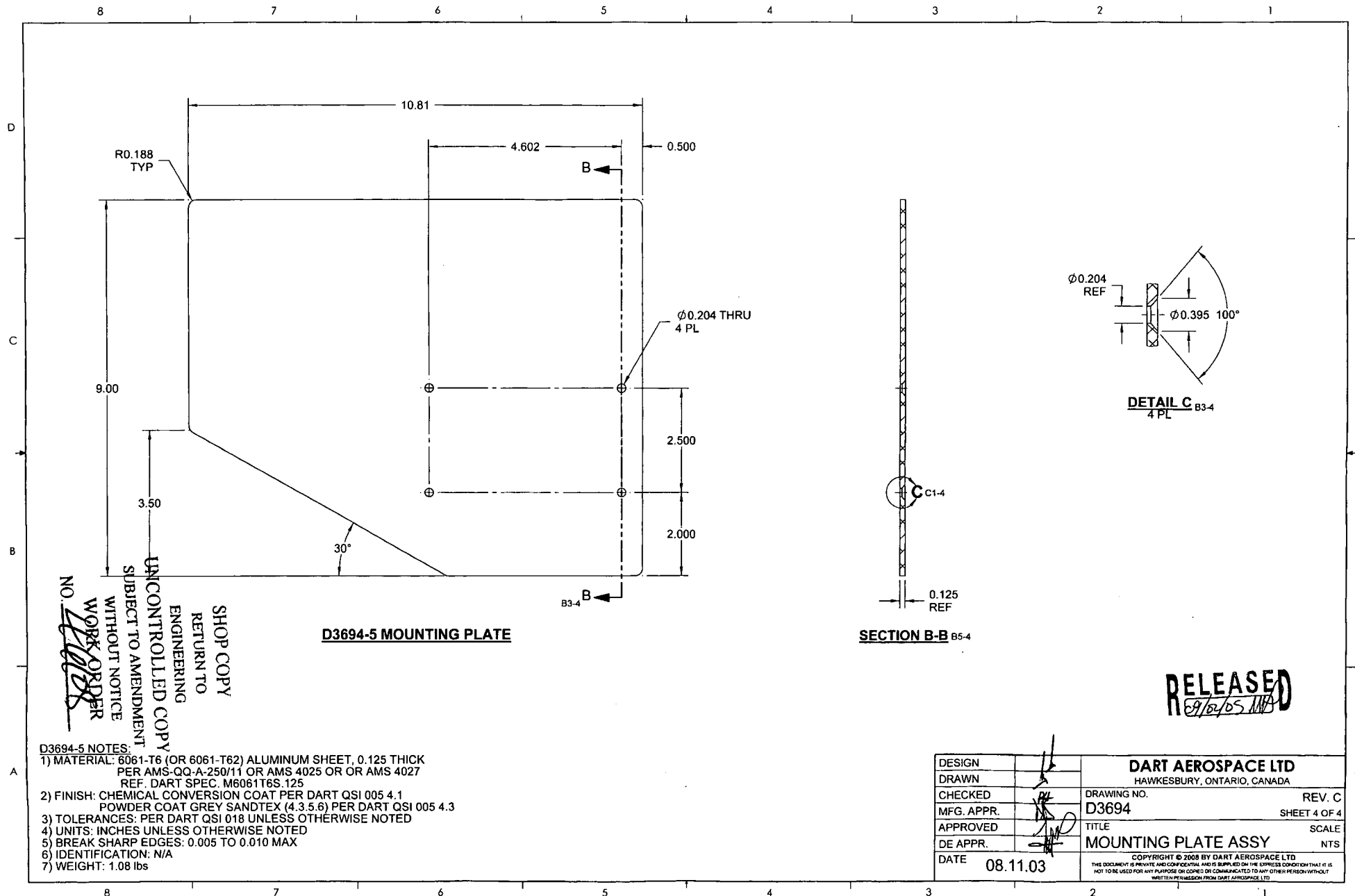
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

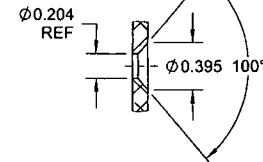


NO. 21008  
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# D3694-5 MOUNTING PLATE

- D3694-5 NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027  
REF. DART SPEC. M6061T6S.125
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.08 lbs

## SECTION B-B B5-4



## DETAIL C B3-4

RELEASED  
6/9/05

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries